

Date: Tuesday, 3/11/2008 11:25:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 37783	
Estimate Number : 10692	
P.O. Number :	Part Number : D32863
This Issue : 3/11/2008 S.O. No. :	Drawing Number : D3286 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 35048	Material :
Written By : <u> </u>	Due Date : 3/18/2008 Qty: <u>40</u> Um: Each
Checked & Approved By : <u> </u>	
Comment : Est A 04.07.14 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 0.3588 f(s)/Unit Total : 7.1757 f(s) 15.4284

304 RD Tube .500 x .049W

Turn (2) D3286-3 per (1) skidtube assembly Dwg D3286

Material: AISI 304/316 SS tubing 0.500" OD x 0.049" wall

(M304TR0.500W.049)

Identify as D3286-3

Batch: M102518 mk 08/03/27 (43)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

Turn blanks as per Folio FA434 and Dwg D3286

Deburr as [per Dwg D3286

mk 08/03/27 (43)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 08/03/27 (43)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

20 08/03/27 (43)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BarkleyJS 08/03/28 (43)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 11:25:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 37783

Part Number: D32863

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

08 - 03 - 28

✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

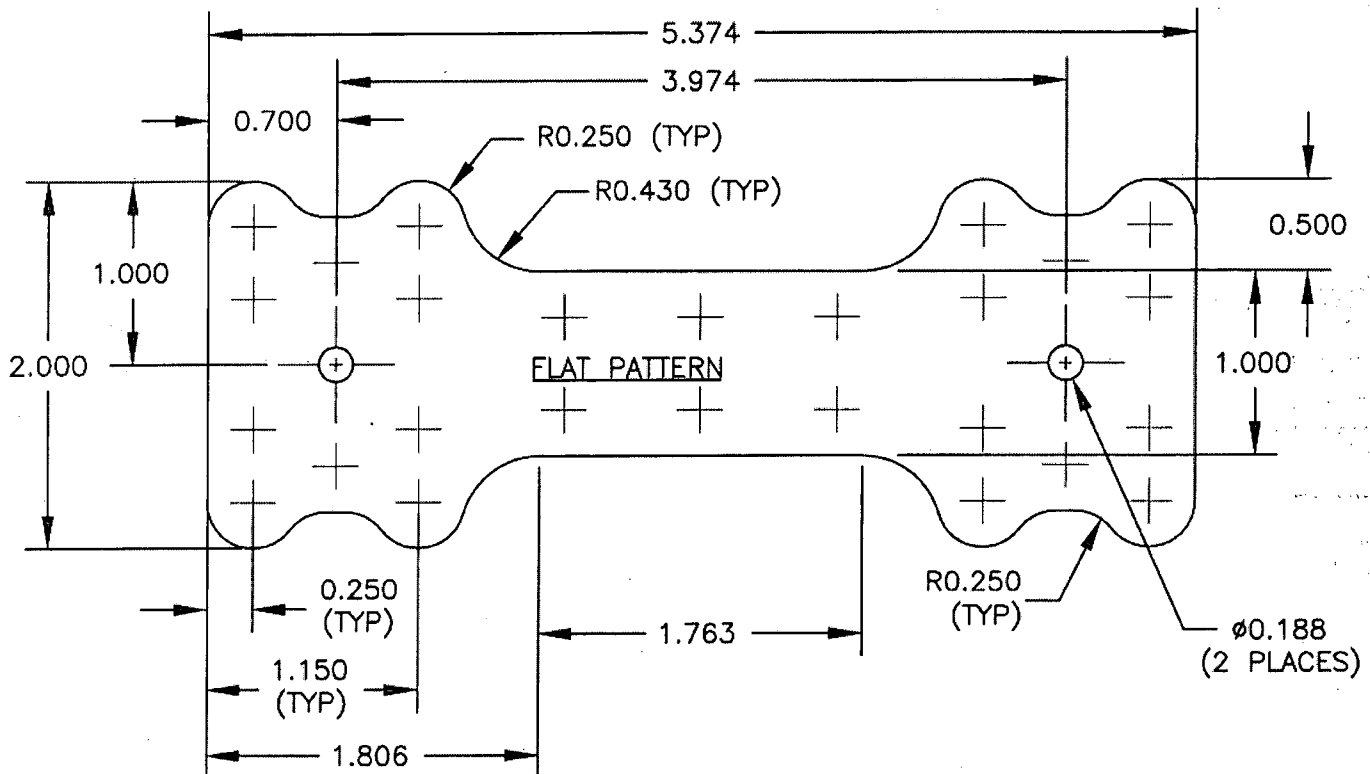
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

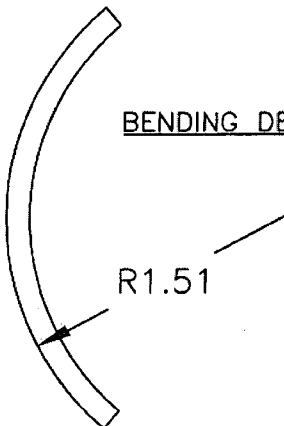


DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 1 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1
A	04.05.06	NEW ISSUE	



+ INDICATES LOCATION OF RIVET HOLES. SHOWN FOR REFERENCE ONLY, DO NOT DRILL.

BENDING DETAIL



RELEASED
04.06.22

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WITHOUT NOTICE
WORK ORDER
NO. 37783

D3286-1 DOUBLER

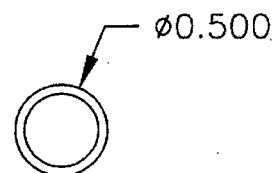
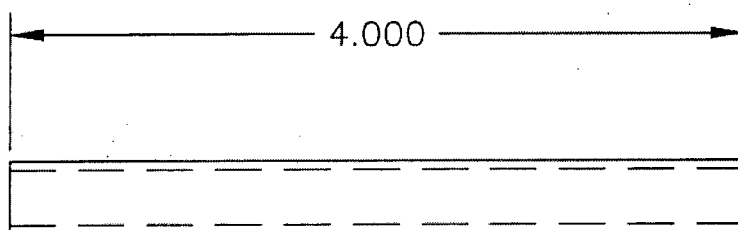
- 1) MATERIAL: AISI 304/316 SS SHEET 0.125" THICK
(REF DART SPEC. M304S11GA)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3286	REV. A SHEET 2 OF 2
DATE 04.05.06		TITLE GROUND HANDLING PARTS	SCALE 1:1



D3286-3 SPACER

- 1) MATERIAL: AISI 304/316 SS TUBING, 0.500 O.D. x 0.049 WALL
(REF DART SPEC. M304TRO.500W.049)
- 2) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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NO. 37783

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